

Work Order ID 137563

October 06, 2015 1:05:38 PM

137563

Page 1

Item ID: D3915-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Light Lid Assembly, Long Basket
 Start Date: 10/6/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 10/13/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3915	E

100 Weld per dwg A/R Aluminum rod Batch: **131560**
 Large Fab

100

Large Fab

Large Fab

Memo

0.04

1- assemble ribs , weld as per dwg D3915 using DT9606A. When welding D4019-3, weld top and bottom then make a small hole in the weld to let air out. Then weld remaining sides of D4019-3 Rib. Let it cool down, then block holes with weld.

DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE A 1/8" GAP TO GET THE ACID AND ALODINE OUT OF BASKET LID FRAME

2- weld hinge, label plate and Mounting plates as per dwg D3915

DAS
24
9-89
DEC 15 2015

110 QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Quality Control

Memo

0.00

① 15-12-15

DAS
9
9-89

Work Order ID 137563

October 06, 2015 1:05:38 PM

137563

Page 3

Item ID: D3915-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Light Lid Assembly, Long Basket
 Start Date: 10/6/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 10/13/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC9- Inspect visual per QSI004- Fusion Welds	0.00							DAS
150									9
QC	Memo	0.00				①	15-12-15		9-89
Quality Control									
155	QC6- Inspect dimensions to drawing	0.00							DAS
155									9
QC	Memo	0.00				①	15-12-15		9-89
Quality Control									
	inspect fit of lid with base								
157	Chemical Conversion Coat per QSI005 4.1	0.00							
157									2349
HandFinish	Memo	0.01				1	15-12-15		
Hand Finishing	1- realodine corners ***do not acid etch***								

Work Order ID 137563

137563

Page 4

October 06, 2015 1:05:38 PM

Item ID: D3915-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Light Lid Assembly, Long Basket
 Start Date: 10/6/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 10/13/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M 1337H.</i> Memo 1- touch up corner with alodine only 2- Plug holes prior to 1ST COAT: START TIME: <u>8:00</u> OVEN TEMPERATURE: <u>320°</u> FINISH TIME: <u>8:30</u> ***** 2nd coat if necessary ***** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00 0.00				<u>1</u>	<u>0</u>	<u>15/12/16</u>	<u>2500</u>
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<u>1x</u>	<u>0</u>	<u>15/12/16</u>	<u>DAS</u> 15 9-88

Work Order ID 137563***137563***

Page 5

October 06, 2015 1:05:38 PM

Item ID: D3915-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Light Lid Assembly, Long Basket
Start Date: 10/6/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 10/13/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Assemble as per dwg	0.00							
180									
HandFinish	Memo	0.02							
Hand Finishing	1- Install webbing as per dwg								
	2- Install placard and label as per dwg								
190	QC5- Inspect part completeness to step on W/O	0.00							
190									
QC	Memo	0.00							
Quality Control									
200	Identify as per dwg & Stock Location: <u>wlc</u>	0.00							
200									
Packaging	Memo	0.00							
Packaging									

04030-043 / 13137562

Work Order ID 137563***137563***

Page 6

October 06, 2015 1:05:38 PM

Item ID: D3915-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Light Lid Assembly, Long Basket
Start Date: 10/6/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 10/13/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

MLJ DEC 17 2015

MLJ DEC 17 2015

Picklist Print

October 06, 2015 1:05:48 PM

Page 1

Work Order ID: 137563

137563

Parent Item: D3915-041

D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 10/6/2015

Required Date: 10/13/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C add realodine DD 10.04.26 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP Rev:E 13.07.08 as per dwg rev.D DD verf:JLM IPP REV:D 13.08.21 DWG REV.E / ECN 13-624 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2957 *D2957* Mounting Plate		Manufactured	No			100	Each	23.0000	4	4		DEC 15 2015	DAS 24 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				WA004				23					
				113165				3					
				137237				20					
D3915-1 *D3915-1* Rib		Manufactured	No			100	Each	0.0000	2	2		DEC 15 2015	DAS 24 9-89
D4016-5 *D4016-5* Hinge Half, Light Lid		Manufactured	No			100	Each	4.0000	3	3		DEC 15 2015	DAS 24 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				WA004				4					
				114302				4					
D4019-3 *D4019-3* Rib		Manufactured	No			100	Each	3.0000	3	3		DEC 15 2015	DAS 24 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				WA004				3					
				127466				3					

**

DEC 15 2015

**

DEC 15 2015

**

DEC 15 2015

**

DEC 15 2015

B137225 → 3

B138604 → 3

Picklist Print

October 06, 2015 1:05:48 PM

Page 3

Work Order ID: 137563

137563

Parent Item: D3915-041

D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 10/6/2015

Required Date: 10/13/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149DN949J

Purchased

No

180

Each

258.0000

34

34

NAS1149DN949J

Washer

Location

Loc Qty

Loc Code

ST260a

100

m133234

100

ST270

158

m128429

4

m128948

28

m128995

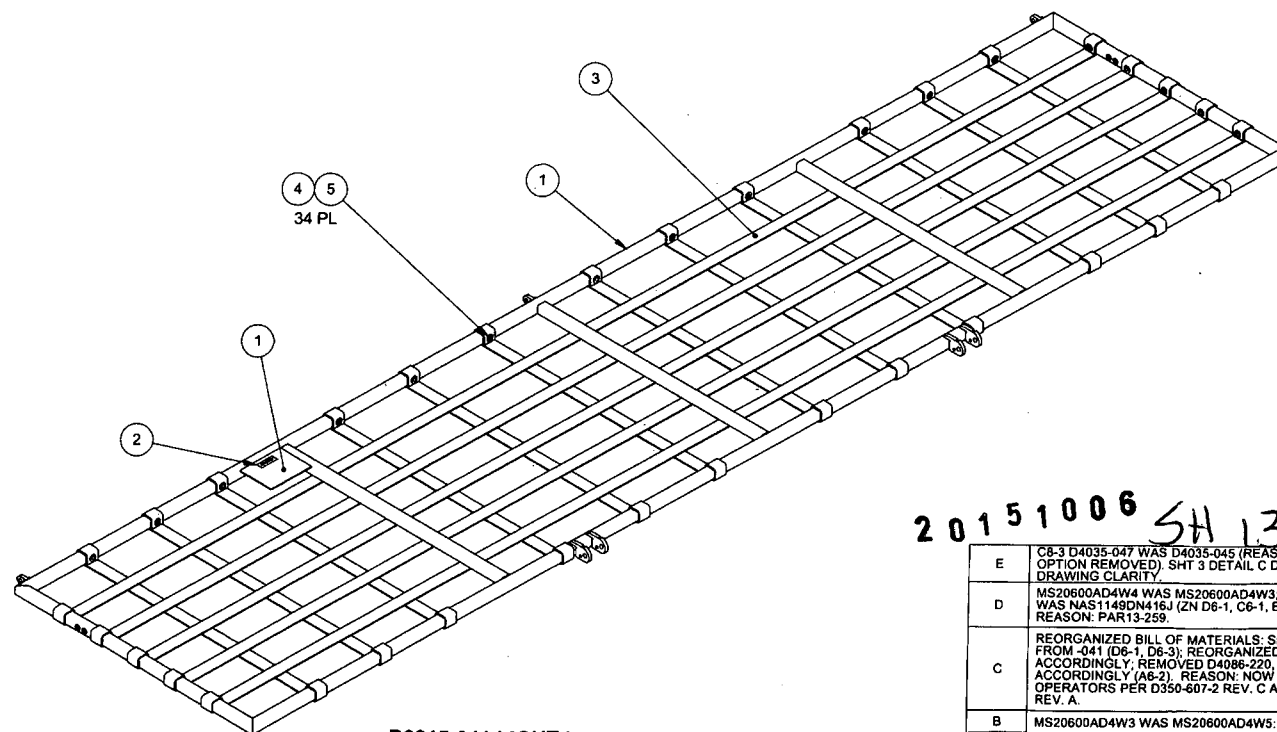
100

m129384

26

34

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3915-041	LIGHT LID ASSY, LONG BASKET ASSY
1	1	D3915-101	BASKET LID WELOMENT ASSY
2	1	D2728-1	DART LOGO LABEL
3	1	D4029-041	WEBBING (LONG BASKET)
4	34	NAS1149DN949J	WASHER
5	34	MS20600AD4W4	RIVET, BLIND, PAN-HEAD



D3915-041 LIGHT LID ASSY, LONG BASKET ASSY

NOTES:

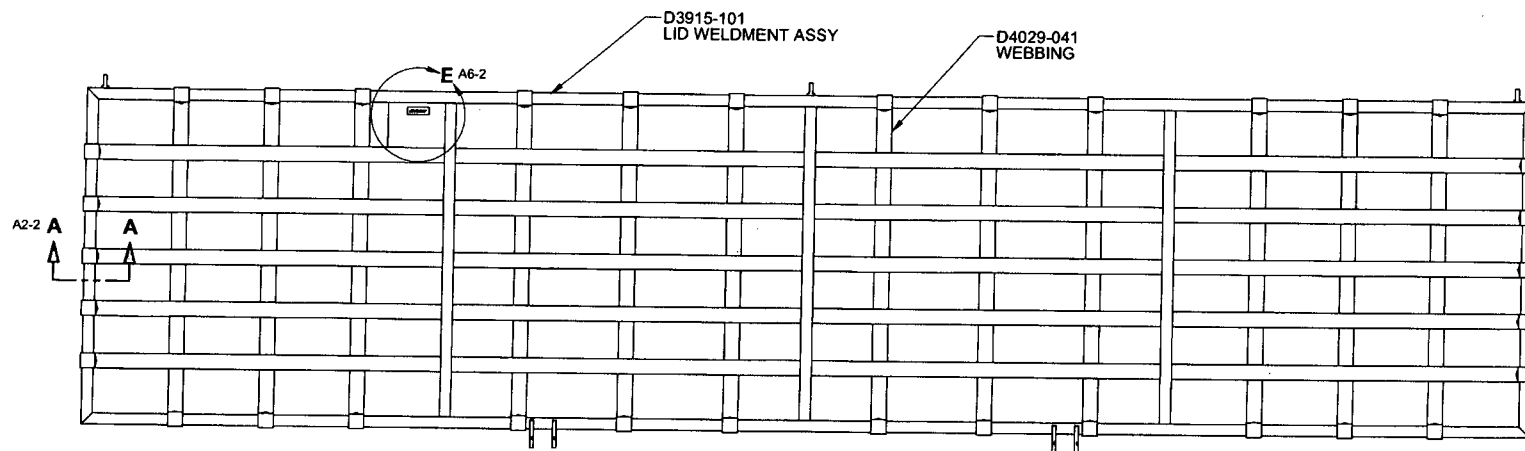
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.98 lbs

20151006

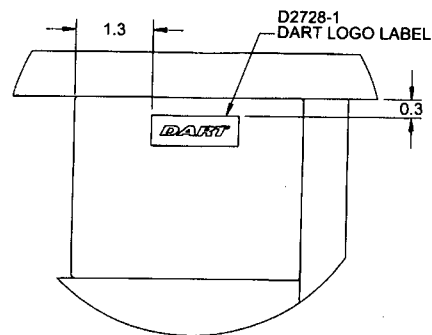
SH 137563

RELEASED
2013-08-16

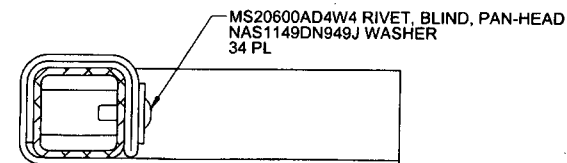
E	C8-3 D4035-047 WAS D4035-045 (REASON PROPRM OPTION REMOVED) SHT 3 DETAIL C DELETED FOR DRAWING CLARITY.	AJS	13.07.18
D	MS20600AD4W4 WAS MS20600AD4W3; NAS1149DN949J WAS NAS1149DN416J (ZN D6-1, C6-1, B1-2) REASON: PAR13-259.	MB	13.06.19
C	REORGANIZED BILL OF MATERIALS: SEPARATED -101 FROM -041 (D6-1, D6-3); REORGANIZED VIEWS ON SHT 3 ACCORDINGLY; REMOVED D4088-220, UPDATED VIEW E ACCORDINGLY (A6-2); REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
B	MS20600AD4W3 WAS MS20600AD4W5: BOM & (B1-2)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	UP	DRAWING NO.	REV. E
MFG. APPR.	SA	D3915	SHEET 1 OF 4
APPROVED	SA	TITLE	SCALE
DE APPR.	SA	LIGHT LID ASSY-LONG BASKET	NTS
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3915-041 LIGHT LID ASSY, LONG BASKET



DETAIL E D6-2

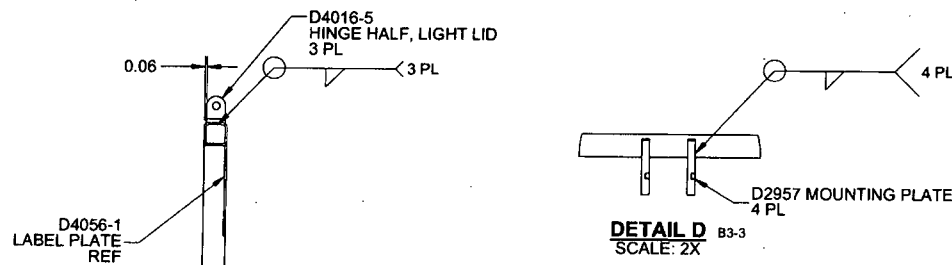


SECTION A-A C8-2
SCALE: 8X

RELEASED
R 2013-08-16
MP

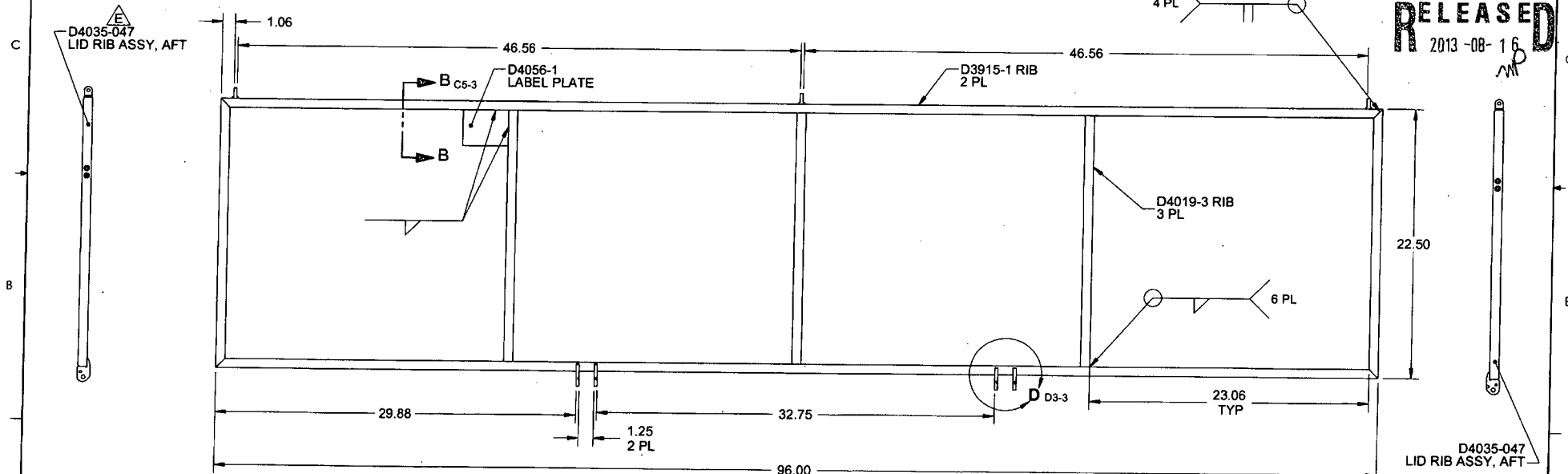
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3915	REV. E
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 4	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LIGHT LID ASSY-LONG BASKET	
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY	P/N	DESCRIPTION
	X	D3915-101	BASKET LID WELDMENT ASSY
1	2	D3915-1	RIB
2	4	D2957	MOUNTING PLATE
3	3	D4016-5	HINGE HALF, LIGHT LID
4	3	D4019-3	RIB
5	2	D4035-047	BASKET LID RIB ASSY, AFT (LIGHT)
6	1	D4056-1	LABEL PLATE, 350 LIGHT BASKET



SECTION B-B C6-3
SCALE: 2X

DETAIL D B3-3
SCALE: 2X



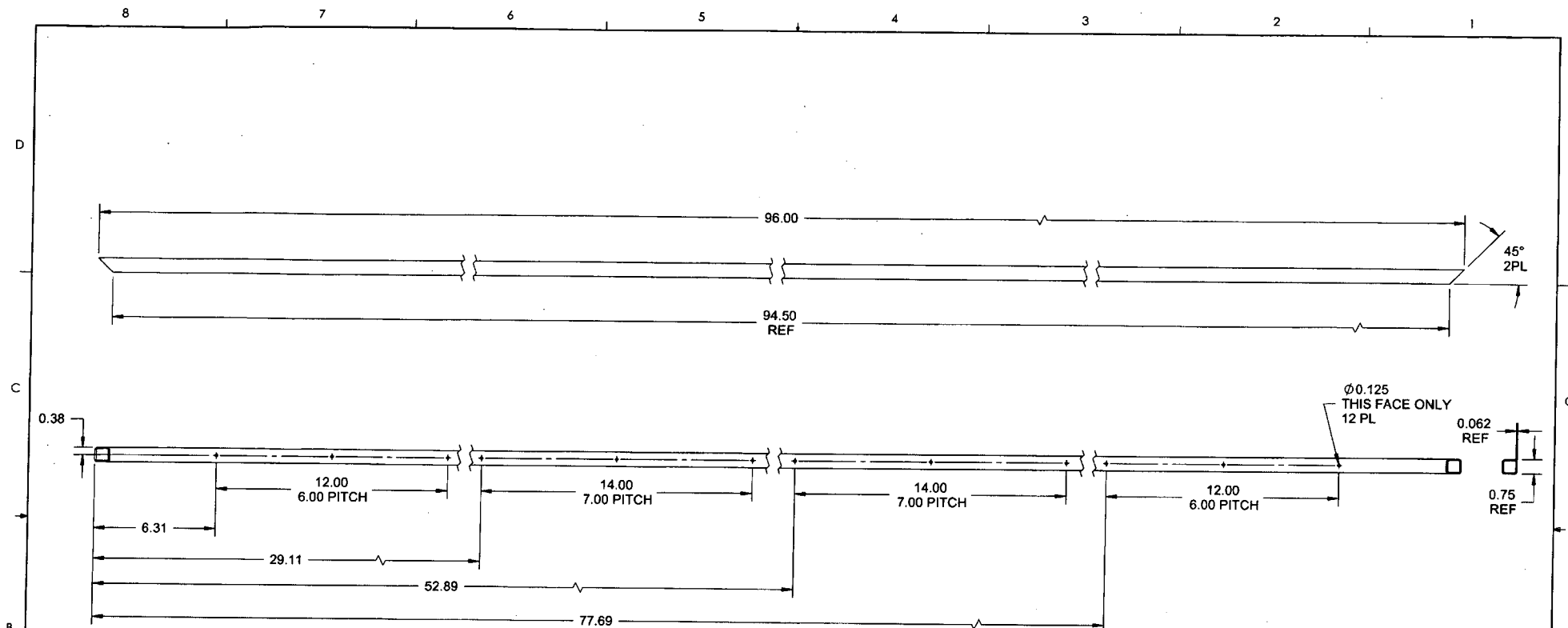
D3915-101 BASKET LID WELDMENT ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 4.82 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3915	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LIGHT LID ASSY-LONG BASKET	NTS
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2013-08-16



D3915-1 RIB

RELEASED
2013-08-16

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING
PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC. M6061T6TS0.750W.062
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.49 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3915	REV. E
MFG. APPR.	<i>[Signature]</i>	TITLE	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	SCALE	
DE APPR.	<i>[Signature]</i>	LIGHT LID ASSY-LONG BASKETNTS	
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	